








Work Order ID 69771

Wednesday, May 18, 2011 3:55:25 PM




Page 1

Item ID: D2362-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: 350 Pre-Flite Step
Start Date: 5/18/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 5/24/2011 Req'd Qty: 4.00  Customer:
Reference:


Approvals: Process Plan:  Date: 4-05-18 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|


| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| D2362 | Rev E1 | | | | | | | | |

100 Weld per dwg A/R Aluminum rod Batch: m114903 0.00
 Large Fab m117884
Large Fab Memo 0.00
Cut D2244 extrusion 3.75" long
Debur D2244-3.75
Weld D2244-3.75 to D2362-7 as per Dwg D2362and QSI 004

11-07-18 2 0

105 QC6- Inspect dimensions to drawing 0.00
 QC Memo 0.00
Quality Control

m 11 07 21 (2)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 QC Memo 0.00
Quality Control

2 0 BE 11/07/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 69771

Wednesday, May 18, 2011 3:55:25 PM

Page 2

Item ID: D2362-041

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Pre-Flite Step

Start Date: 5/18/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2 0 11-7-21

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 0 11-6-21

140

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Mask bracket and apply black anti-skid paint as per QSI 005 4.4

2 0 11-07-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 69771

Wednesday, May 18, 2011 3:55:25 PM

Page 3

Item ID: D2362-041

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Pre-Flite Step

Start Date: 5/18/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 22 (2)

160

Identify as per dwg & Stock Location: 485

0.00



Packaging

Memo

0.00

Packaging

11/7/22 228

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/25

11-07-22 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 3:55:31 PM

Page 1

Work Order ID: 69771

Parent Item: D2362-041

Parent Item Name: 350 Pre-Flite Step



Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C000.06.26 Removed P/O for powder coat EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2244-116 Step Extrusion | | Manufactured | No | | | 100 | Each | 139.0000 | 1 | 4 | | 11-07-18 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL | 94 | |
| 60307 | 94 | |
| WA | 45 | |
| 57850 | 5 | |
| 60307 | 40 | |

| | | | | | | | | | | | | | |
|--------------------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|----------|--|
| D2362-7 Support Bracket | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 4 | | 11-07-18 | |
|--------------------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|----------|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA002 | 2 | |
| 58912 | 2 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries



RELEASED
98.12.14 KE

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|----------------------|-----------------------------|
| BW | CP | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| KE | CP | D2362 |
| DATE | TITLE | REV. E |
| 98.12.04 | STEP SUPPORT BRACKET | 1/2 |
| A | 95.02.15 | NEW ISSUE |
| B | 95.03.22 | CHANGED RUBBER TO D2397 |
| C | 96.01.22 | ADD D2362-5 |
| D | 97.05.21 | ADD D2362-7 |
| E | 98.12.04 | REDRAWN, ADD 2397-5 |

UNDER REVIEW

01.03.15 CP

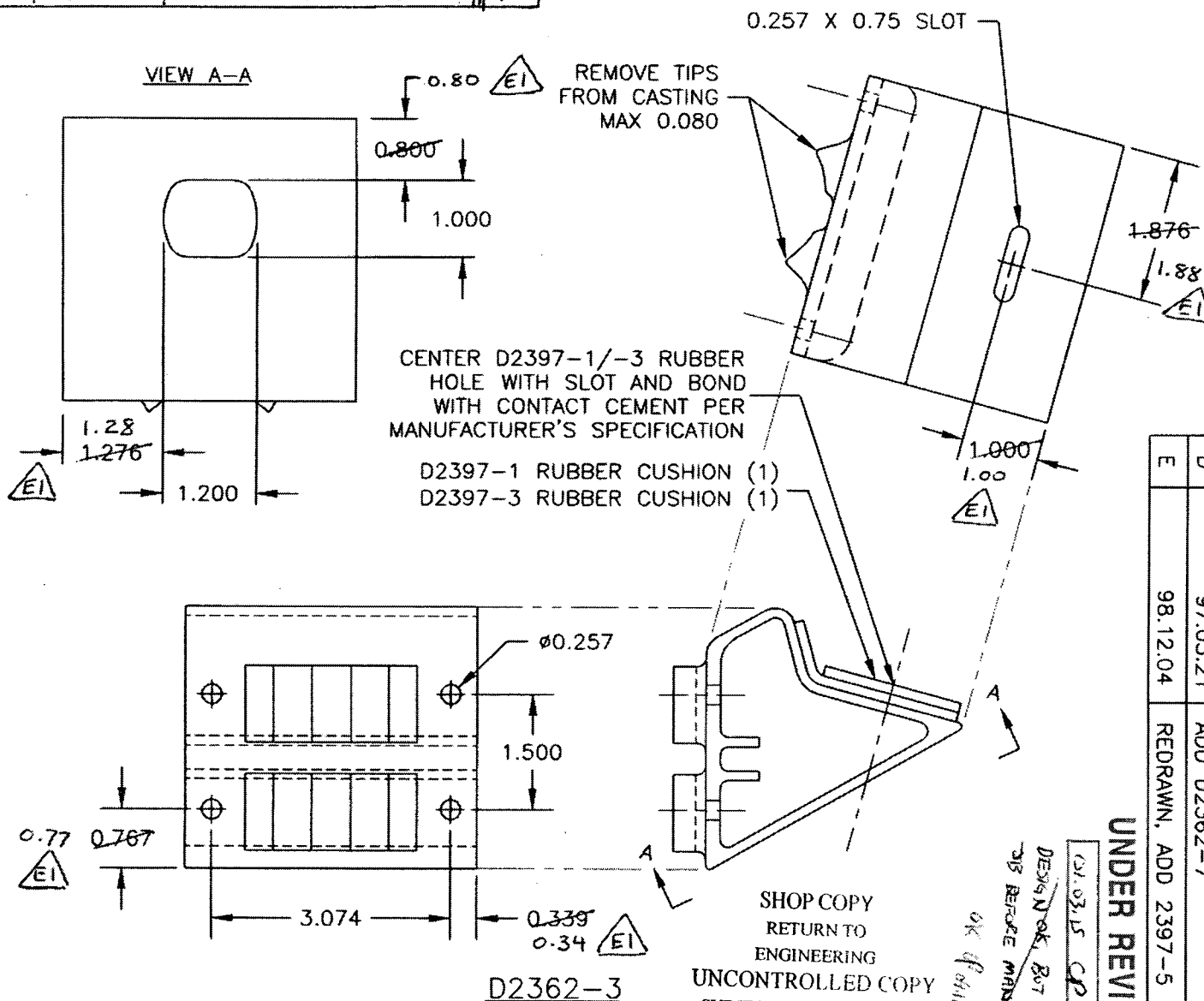
DESIGN OK, BUT CHECK WITH
3/5 BEFORE MANUFACTURE

OK 01/11/04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69771

01-05-18

EI 03.10.07 TOLERANCE CHANGE ~~RF~~



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

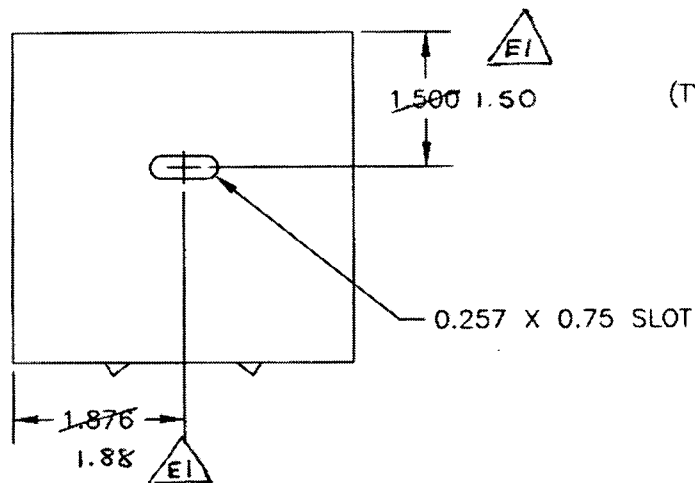
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NOTE: Date & initial all entries



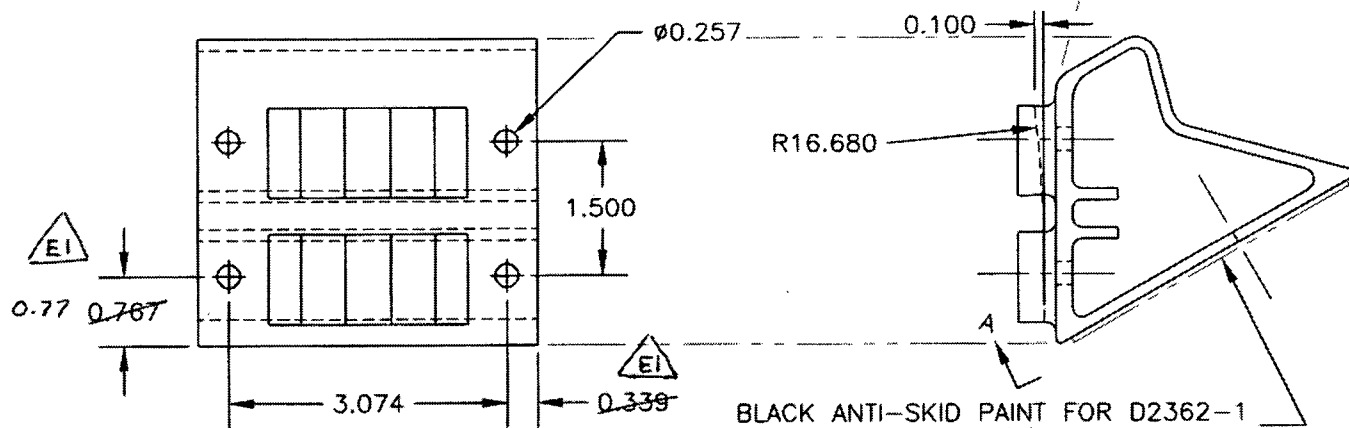
| | | | |
|---------|----------|----------|-----------------------------|
| DESIGN | BW | DRAWN BY | DART AEROSPACE LTD |
| CHECKED | KE | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE | 98.12.04 | TITLE | D2362 |
| | | STEP | SUPPORT BRACKET |
| | | SCALE | 1:2 |

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
1998.12.14
UNDER REVIEW

DESIGNED, DETAIL CHECK BY
OR BEFORE MANUFACTURE

OK 1/10/99

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

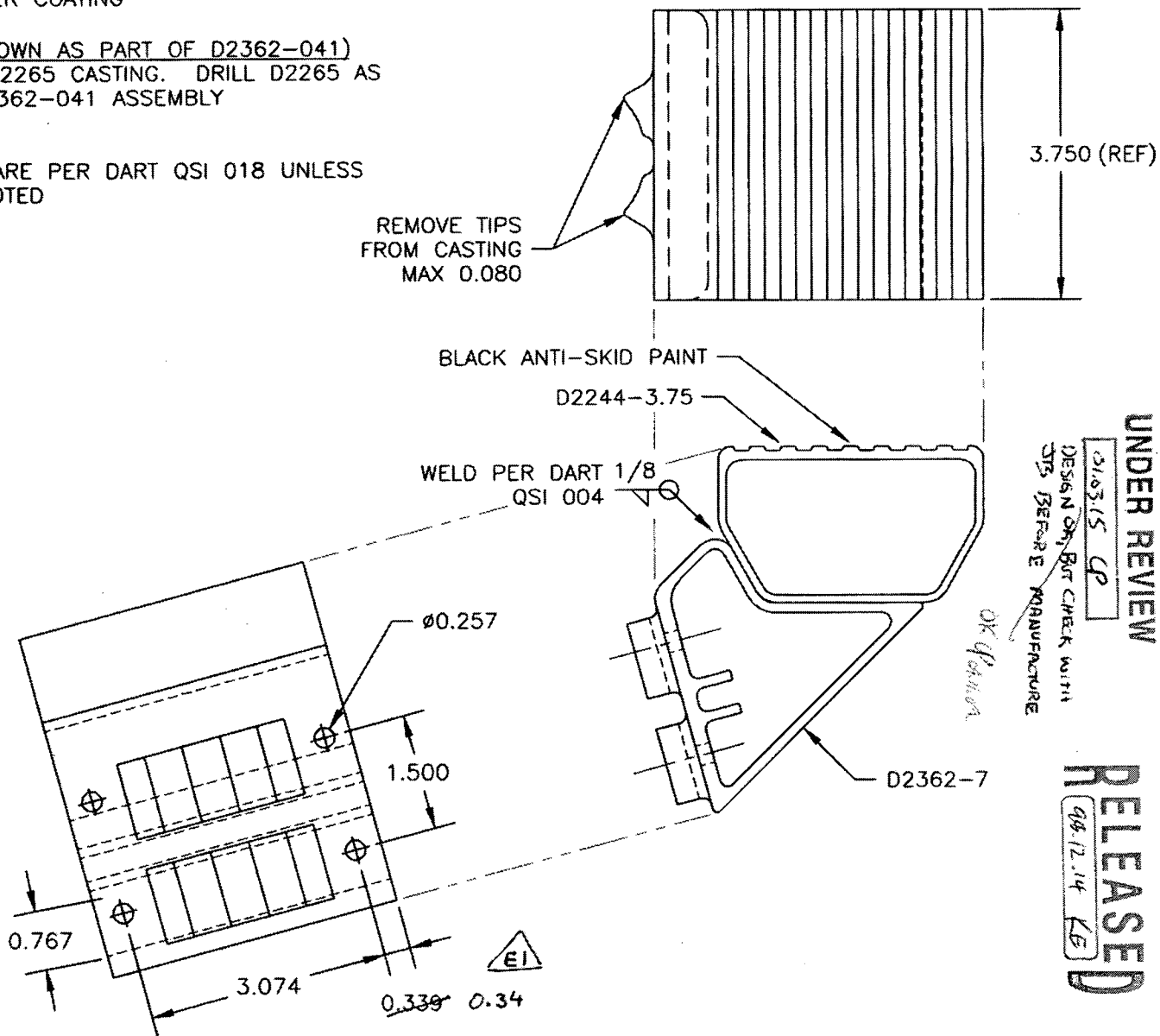
D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



| | | |
|----------|----------------------|-----------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
| BW | CP | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| KE | KE | D2362 |
| DATE | TITLE | SHEET 3 OF 3 |
| 98.12.04 | STEP SUPPORT BRACKET | SCALE |
| | | 1:2 |

UNDER REVIEW

RELEASED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

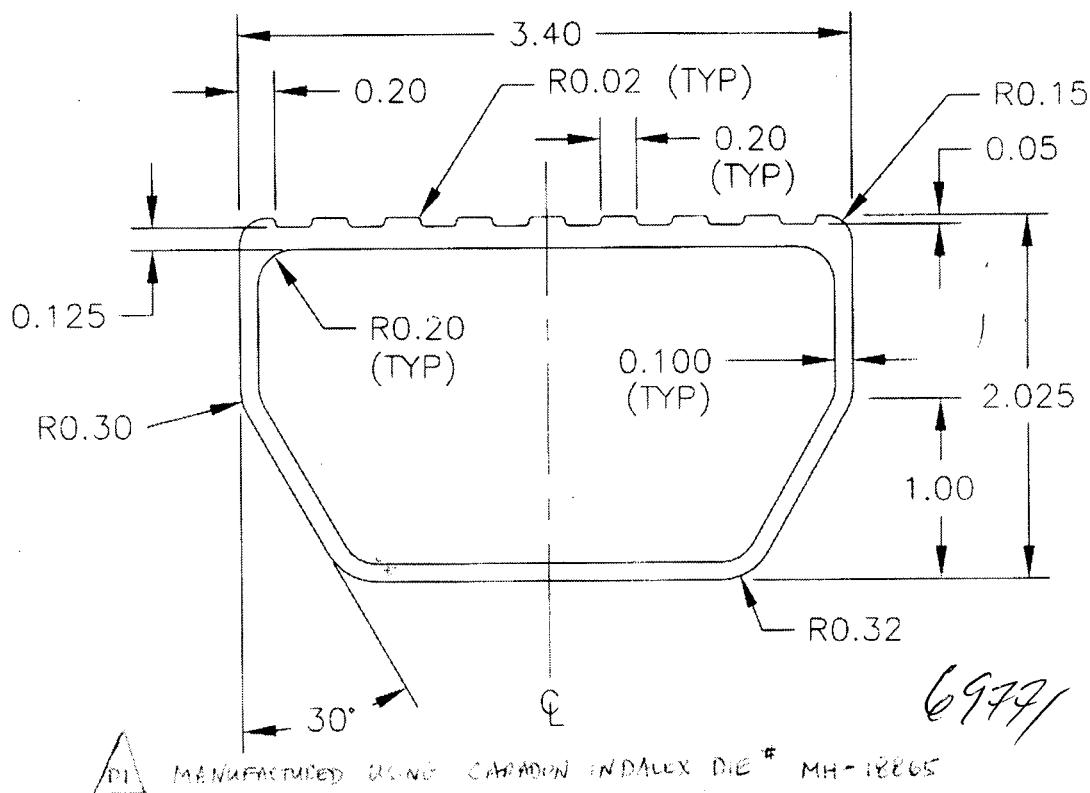
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NOTE: Date & initial all entries



| | | | | | |
|----------------------|----------|---|--|---|--|
| DESIGN BW | | DRAWN BY <i>[Signature]</i> | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | | APPROVED <i>[Signature]</i> | | DRAWING NO. D2244 REV. D SHEET 1 OF 1 | |
| DATE 98.11.18 | | TITLE STEP EXTRUSION | | SCALE 1:1 | |
| A | 94.07.05 | NEW ISSUE | | | |
| B | 94.07.11 | REDESIGNED | | | |
| C | 94.08.08 | REDESIGNED | | | |
| D | 98.11.18 | REMOVED 6005A MATERIAL INCORPORATED DEO 9081 | | | |
| D1 | 01.04.17 | ADDED DIE # <i># 40</i> | | | |

RELEASED
48129 26



PART NUMBER D2244-XX.X
XX.X IS CUT LENGTH IN INCHES

MATERIAL: 6061-T6 (QQ-A-200/8)

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED